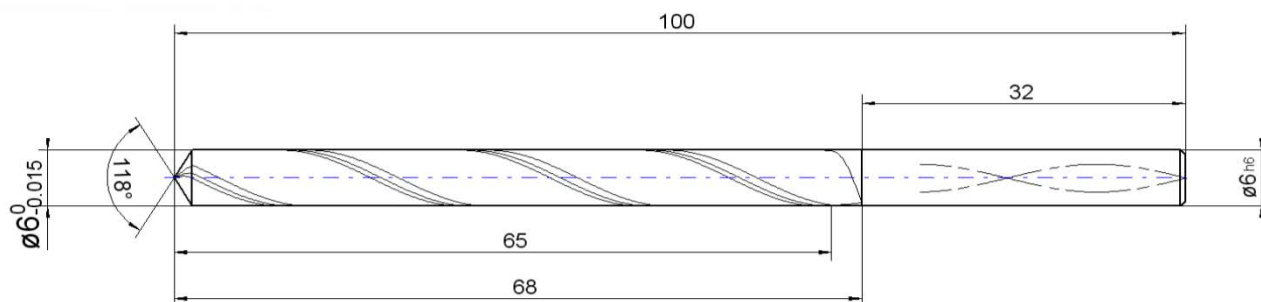













## Carbide Drill Ø6 Z2

A05-054



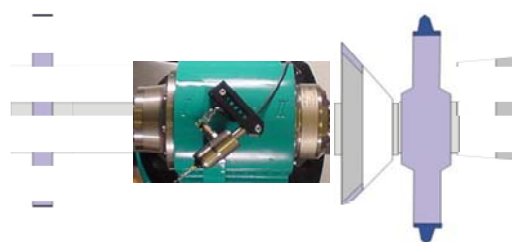
### 1. Cycletime for Production

Workpiece:	Ø6 Ltot 100, LC 65 mm					
Material	CARBIDE					
Operations						
Feed [mm/Min]	2000	60	80	150	70	100
Power [kW]		3	2	1	1	1
Cutting speed [m/s]		18	20	22	22	22
Used wheels						
Grinding time [s]	12	161	19	83	40	36
Total cycle time	5 Min 51					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	DXF Ø150 D64
2	12V9 Ø125 D64
3	1A1 Ø125 D64
4	11V9 Ø100 D64



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2 1 4

### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG      Coolant: Synthetic Oil, pressure 6 bar  
 Control: Fanuc 310i      Software: Quinto 5  
 Accessories: Steady Rest  
 Responsible engineer: OP, 27.2.14

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland  
 Subsidiaries in: France, Deutschland, Italia, United States, China

